

Work Order ID 51212

August 10, 2009 8:59:06 AM



Page 1

Item ID: D3319-1

64

Accept



Setup Start



Revision ID: B

Item Name: Wearplate

Stop



Start Date: 8/10/09 Start Qty: 12.00



Cust Item ID:

Required Date: 8/14/09 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 09-08-09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3319

Rev B

18

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3319
Deburr if necessary

☐ Dwg Rev:

B

☐ Prog Rev:

B

☐ 12-

B 9-8-11

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 9-8-11

(18)

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

=> 5 09/08/11

(18)

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Required Date: 8/14/09 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary								
140 	NC BRAKE	0.00							
Brake NC	Memo	0.00							
Brake NC	1- Form using DT8326 & DT8261 as per Dwg D3319Rev: <u>B</u> 12- Form flat on press using DT8776 block								
150 	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control									

N/A

8/09/08/12

18 0

=> 5 09/08/12

(XTS)

f

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Page 3

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Revision ID: B

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Item Name: Wearplate

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Cust Item ID:

Required Date: 8/14/09 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- Layout weld location as per Dwg D3319 using jig D3319-IT3-2- Weld hard surface using D3319-IT2 per QSI 004 and Dwg D3319 Rev: ☐ Qty Part Number Description Batch ☐ A/R N/A 7560
Hardcoat Rod M109813

EZ 9-8-14

X18

170

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

=> 509/08/14

X18

φ

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 502/08/14

X18

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51212

August 10, 2009 8:59:06 AM



Page 4

Item ID: D3319-1

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Setup Start



Revision ID: B

Stop



Item Name: Wearplate

Start Date: 8/10/09

Start Qty: 12.00



Cust Item ID:

Required Date: 8/14/09

Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

M109091

0.00

Powder Coating

START TIME:

7:15pm

OVEN TEMPERATURE:

FINISH TIME:

320°F

09/08/17 JH (18) Ø

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

GM 09 - 08 - 17 (18)

210

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify on inside surface using a permanent fine point marker with the following: ☐TCCA-PDA, Dart Aerospace Ltd. ☐P/N: D3319-1, B/N: BXXXXX ☐For Product Eligibility see PDA05-18 ☐and Stock ☐Location: 492

9/8/18 (18X) SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51212

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Page 5

Item ID: D3319-1

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Item Name: Wearplate

Start Date: 8/10/09 Start Qty: 12.00



Cust Item ID:

Required Date: 8/14/09 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/08/20

MF 09-08-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

August 10, 2009 8:59:05 AM

Work Order ID: 51212



Parent Item: D3319-1RevB



Parent Item Name: Wearplate



Start Date: 8/10/09

Required Date: 8/14/09

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M1010S18GA		Purchased	No			100	sf	155.3114	7.9326			
												
1010/1025 SHEET .048												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	155.3114	
106603	1	
109022	3	
109948	3	
111964	148.3114	

111964 1B 9-8-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

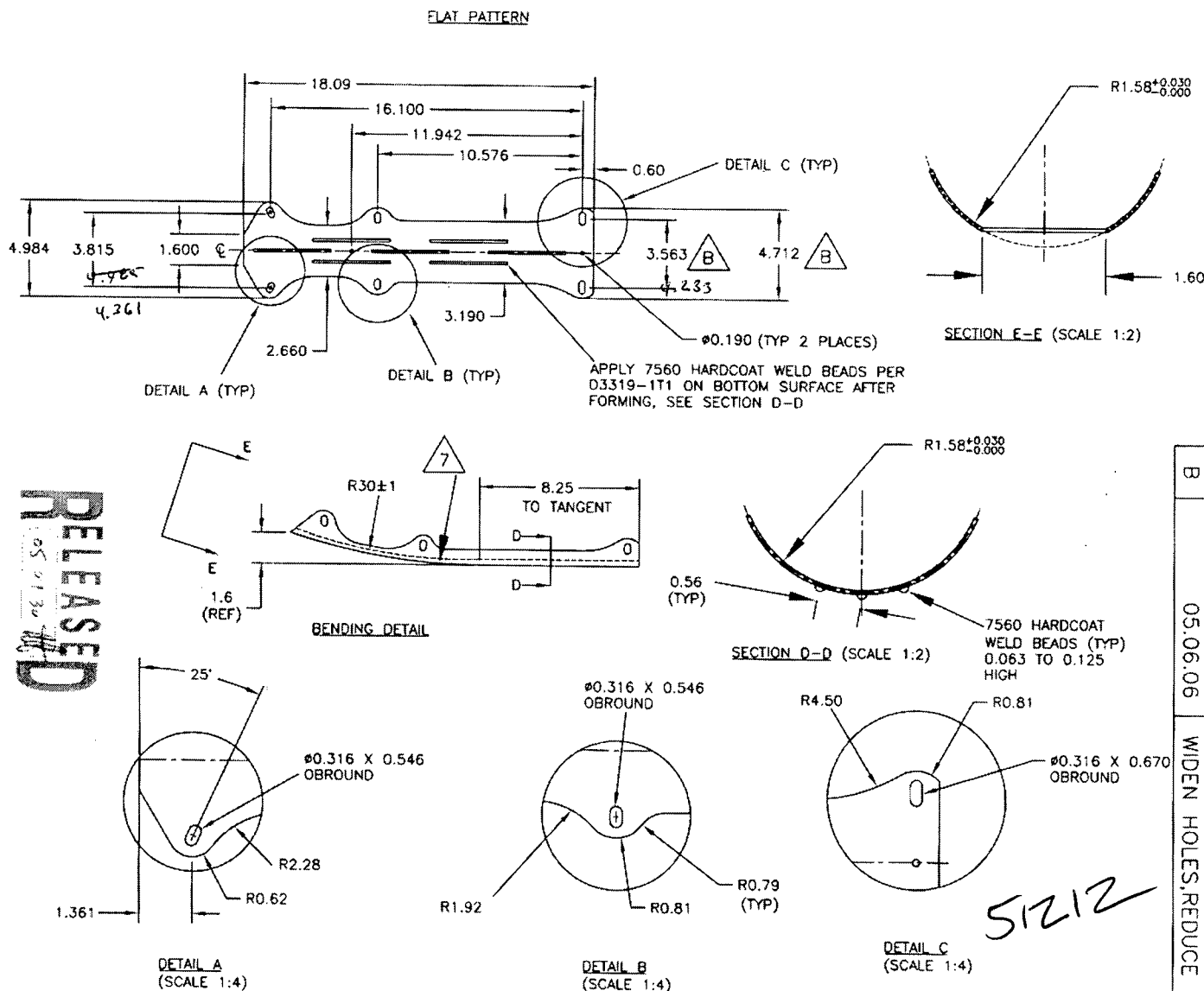
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
P41	84	HAMMERSBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
DATE	DATE	D3319
05.06.06	04.09.24	WIDEN HOLES, REDUCE WIDTH -3/-5/-7
	05.06.06	WEARPLATE
		SCALE
		1:8



D3319-1 WEARPLATE

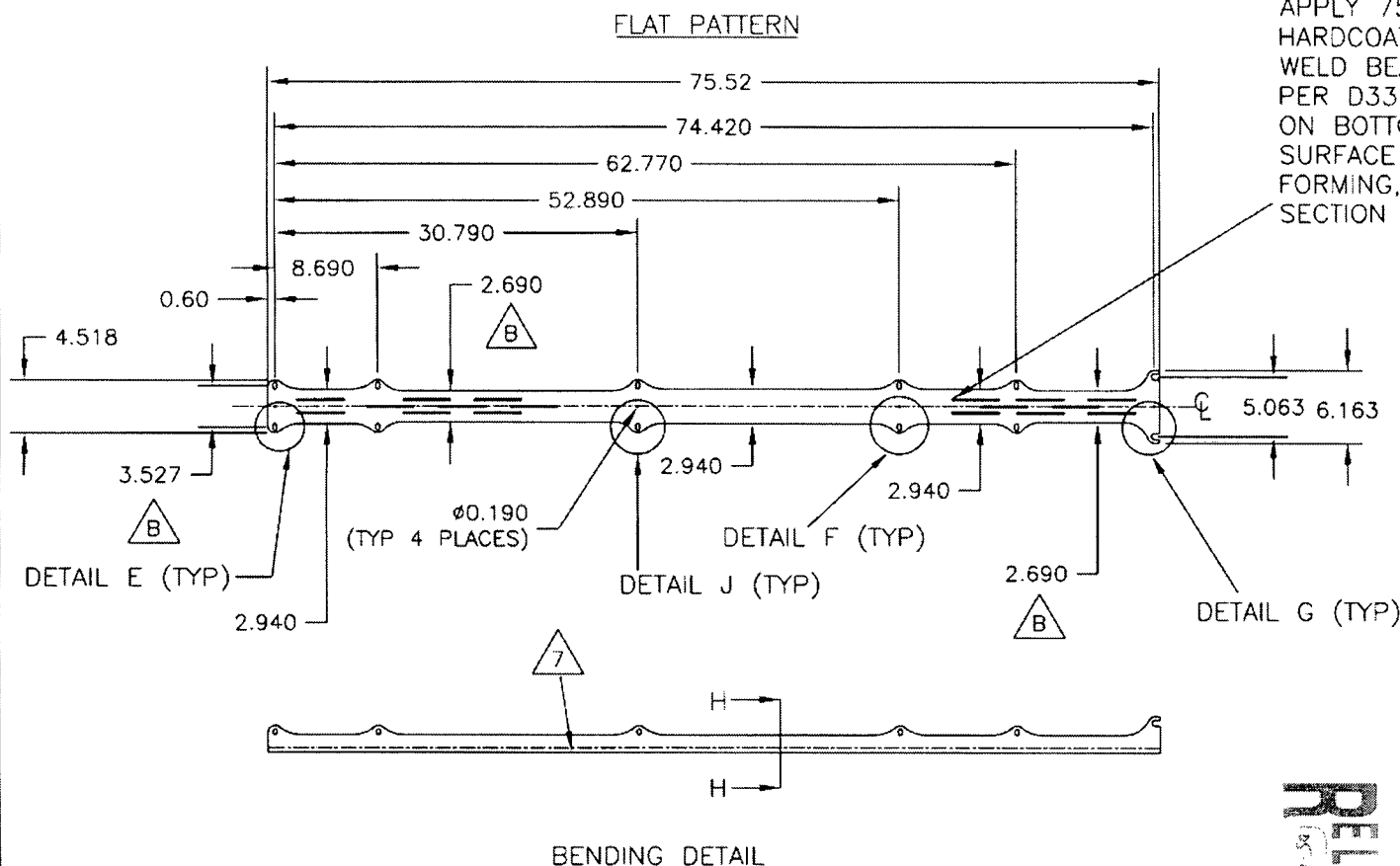
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA C40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

RELEASED
05 01 30

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. B
05.06.06	D3319	SHEET 2 OF 5
	WEARPLATE	SCALE
		1:15

APPLY 7560
HARDCOAT
WELD BEADS
PER D3319-3T1
ON BOTTOM
SURFACE AFTER
FORMING, SEE
SECTION H-H



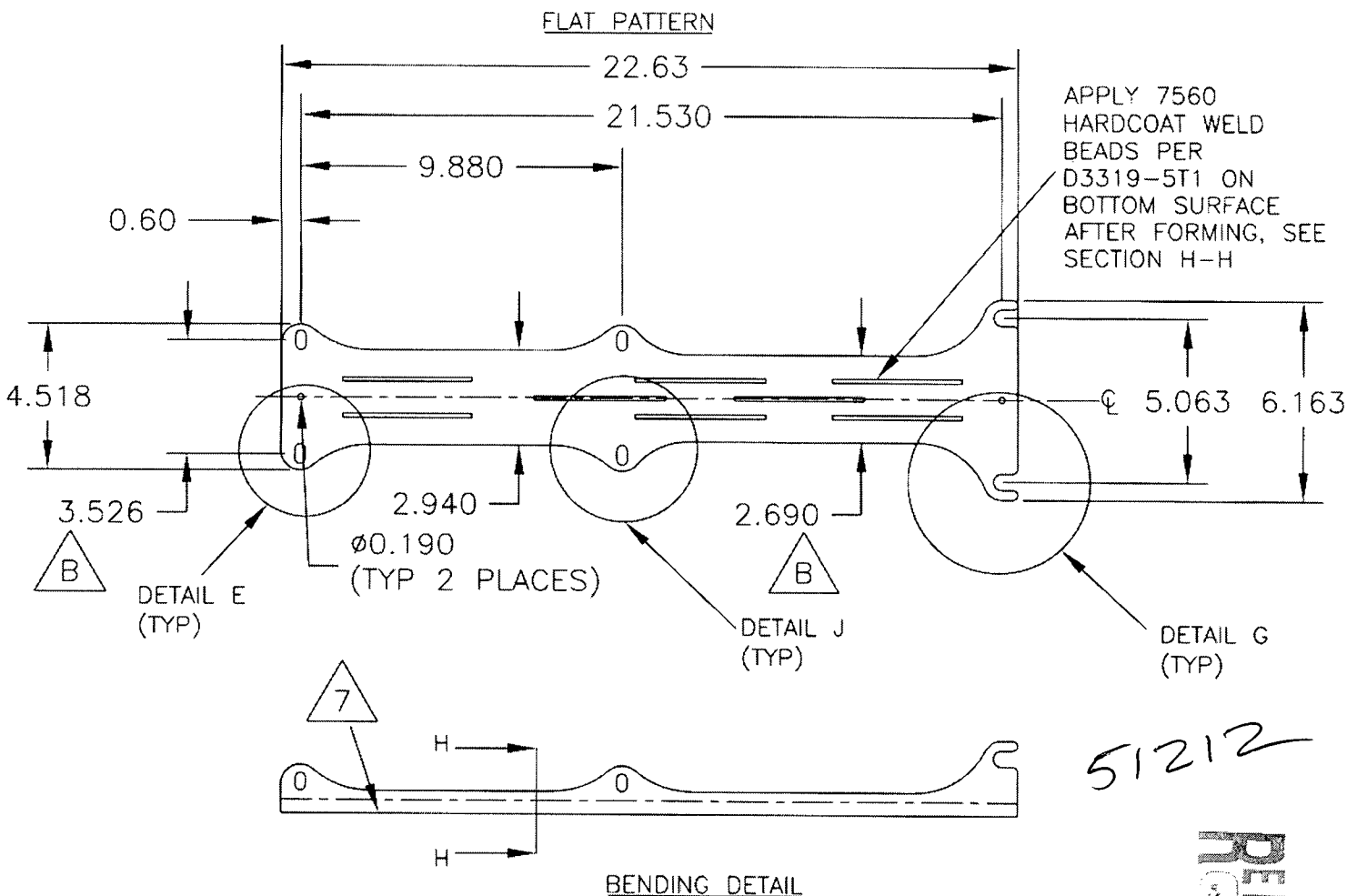
D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

RELEASED

5212

DART



DESIGN	Q21	DRAWN BY	Q21	DART AEROSPACE LTD
CHECKED	Q21	APPROVED	Q21	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	TITLE	D3319	REV. B
		WEARPLATE		SHEET 3 OF 5
				SCALE 1:5

D3319-5 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

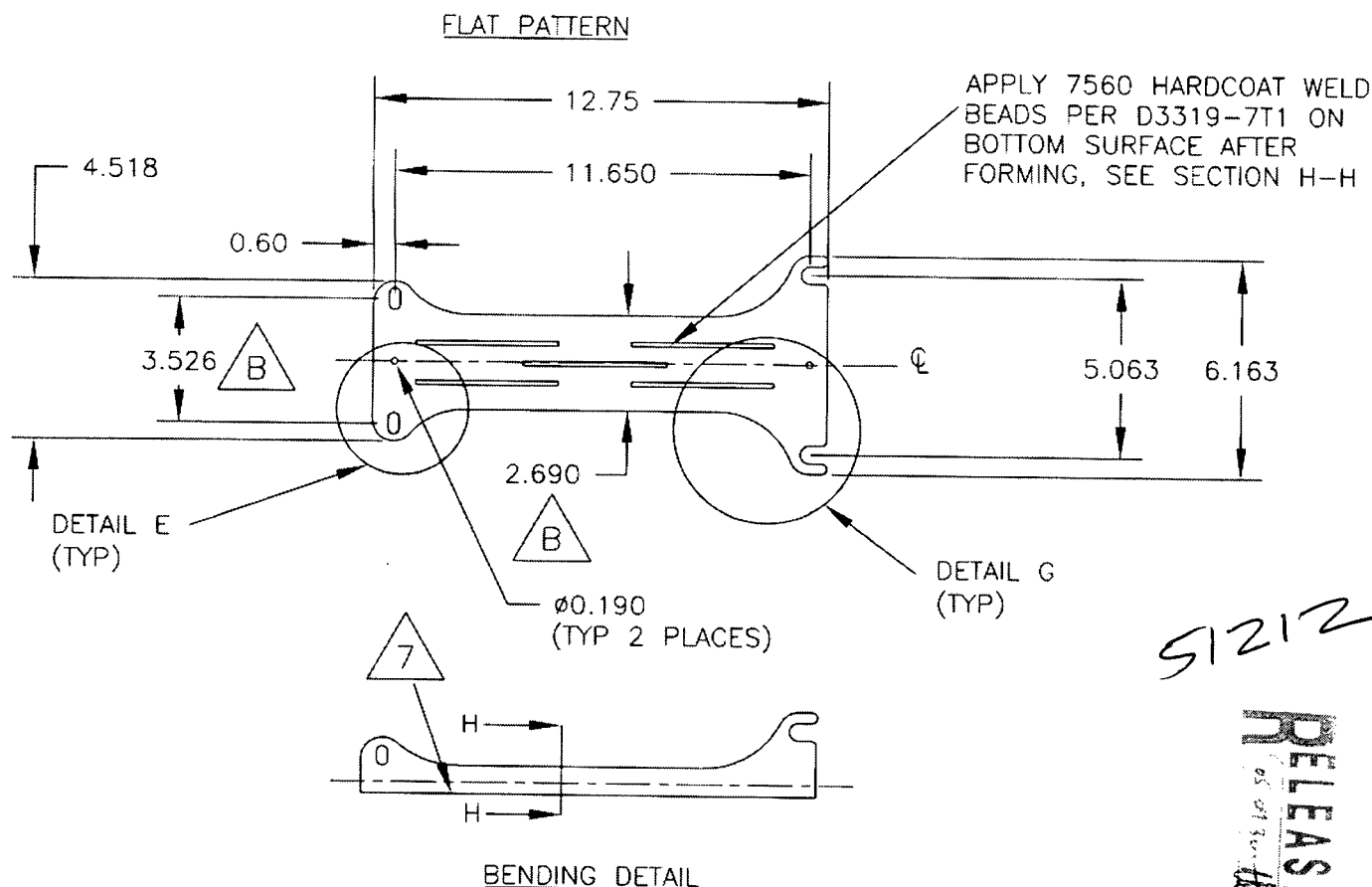
RELEASED

51212

DART

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	APPROVED	PH	DRAWING NO. D3319
DATE	05.06.06	TITLE	WEARPLATE	REV. B SHEET 4 OF 5
		SCALE	1:5	

51212
RELEASED

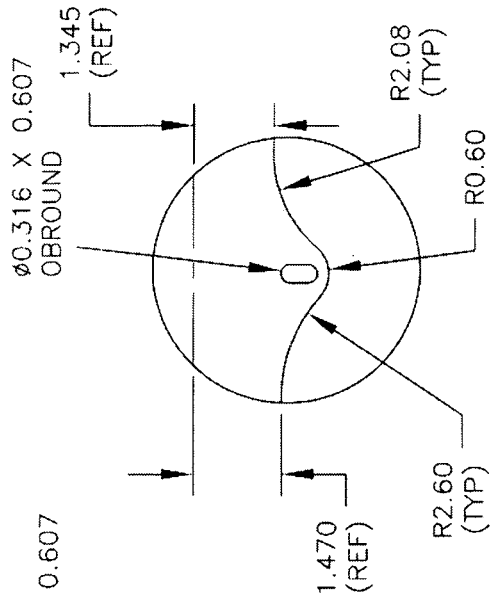


D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

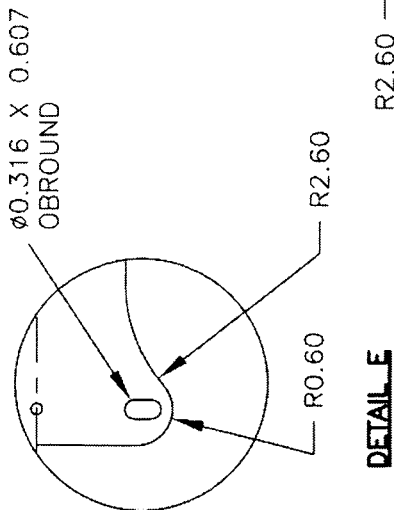
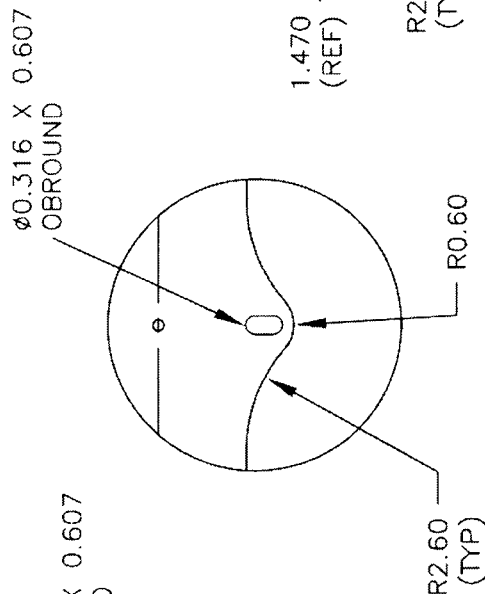
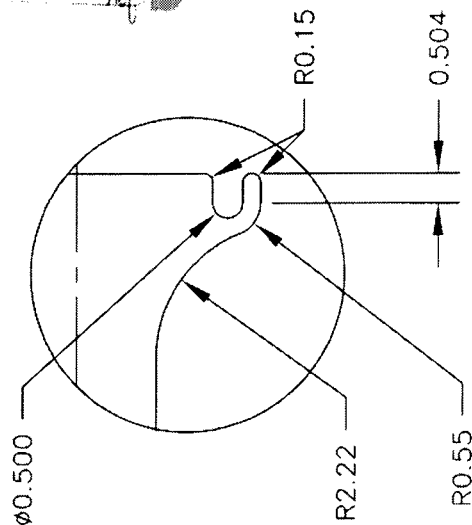


DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JH</i>	APPROVED <i>JH</i>	DRAWING NO. D3319	REV. B SHEET 5 OF 5
DATE 05.06.06		TITLE WEARPLATE	SCALE 1:3

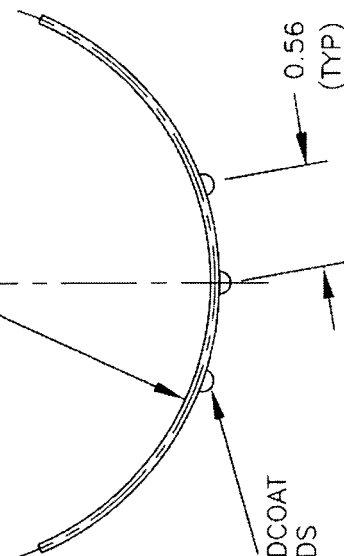


51212

RELEASED
15-09-30



R1.58^{+0.030}_{-0.000}



SECTION H-H
(SCALE 1:1)

7560 HARDCOAT
WELD BEADS
(TYP)
0.063 TO 0.125
HIGH

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